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D4634-145
Job Sheet 202526



Part No: D4634-145

Job Qty: 1 pcs

Part Name: Aft, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/30/19

Job Tracking No:

Due Date: 11/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4634 REV.H SHEET 9 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL
VERIFIED BY:JLM IPP Rev C 13/07/09 Dwg Update DL ver: DD IPP Rev D Dwg Update 13/12/23 DL IPP
REV E Dwg update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	11/15/19		0.00	1.47	Small Fab - 1		NOV 07 2019
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	1 pcs	11/15/19		0.00	0.00	QC 5 - 10		NOV 19 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	11/15/19		0.00	0.00	Packaging 3 - 1 - B4B		NOV 19 2019
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		

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[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

Packaging 3 - 4 - B4B	
Packaging 3 - 5 - B4B	
Packaging 3 - 6 - B4B	
Packaging 3 - 7 - B4B	
Packaging 3 - 8 - B4B	
Packaging 3 - 9 - B4B	
Packaging 3 - 10 - B4B	
Packaging 3 - 11 - B4B	
Packaging 3 - 12 - B4B	
Packaging 3 - 13 - B4B	
Packaging 3 - 14 - B4B	
Packaging 3 - 15 - B4B	
Packaging 3 - 16 - B4B	
Packaging 3 - 17 - B4B	
Packaging 3 - 18 - B4B	
Packaging 3 - 19 - B4B	
Packaging 3 - 20 - B4B	
Packaging 3 - 21 - B4B	
Packaging 3 - 22 - B4B	
Packaging 3 - 23 - B4B	
Packaging 3 - 24 - B4B	
Packaging 3 - 25 - B4B	
Packaging 3 - 26 - B4B	
Packaging 3 - 27 - B4B	
Packaging 3 - 28 - B4B	
Packaging 3 - 29 - B4B	
Packaging 3 - 30 - B4B	
Packaging 3 - 31 - B4B	
Packaging 3 - 32 - B4B	
Packaging 3 - 33 - B4B	
Packaging 3 - 34 - B4B	
Packaging 3 - 35 - B4B	
Packaging 3 - 36 - B4B	
QC 21 - SA - 21	
QC 21 - SA - 70	
QC 21 - SA - 53	

140 QC 21 - SA

1 pcs

11/15/19

0.00 0.00

Part Op 110 - Small Fab (Small Fab) Assemble as per Dwg D4634-145 Bond foam core to inside of panel 3M Scotch Weld 1300
 Descriptions: Batch: 5214697 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with
 wash & wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (se
 note 8) Batch # 5156491 Expiry Date 6/3/21 3- Apply labels as per Dwg. and seal with 3M
 3950 edge sealer (see note 9) Batch: m13890
 120 - QC5 (QC5- Inspect part completeness to spec)

130 - Packaging3 (Identify as per dwg & Stock Location:) QC5- Inspect part completeness to step on W/O
140 - QC21 (QC21- Final Inspection - Work Order Release)QC21- Final Inspection - Work Order Release

Part / Item	Component Name	Quantity	Operation	Container
CCR264SS-3-03	Cherry Rivet	4 Ea (4 ea)	110-Small Fab - 1	5180315
D4634-5	Aft, Center Ceiling Panel	1 pcs (1 ea)	110-Small Fab - 1	5131092
D4636-5	Bracket	1 pcs (1 ea)	110-Small Fab - 1	5129441
D4647-1	Doubler	1 pcs (1 ea)	110-Small Fab - 1	5002354
D4664-5	Spacer	6 pcs (6 ea)	110-Small Fab - 1	5229409
D4712-1	Bracket	1 pcs (1 ea)	110-Small Fab - 1	5227769
D4732-17	Label	1 pcs (1 ea)	110-Small Fab - 1	3104151
D4732-23	Label	1 pcs (1 ea)	110-Small Fab - 1	5103525
D4732-27	Label	1 pcs (1 ea)	110-Small Fab - 1	5224281
D5021-5	Foam, Center Panel, Aft	1 pcs (1 ea)	110-Small Fab - 1	5104331
MPNY-750S-9-C	Mounting Pad	1 pcs (1 ea)	110-Small Fab - 1	5227769
MS20426AD4-6	Rivet	9 pcs (9 ea)	110-Small Fab - 1	5140391
MS21059L08	Nut	2 Ea (2 ea)	110-Small Fab - 1	
		2 Ea (2 ea)	110-Small Fab - 1	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	CCR264SS-3-03	4	176	0
	D4634-5	1	2	0
	D4636-5	1	41	0
	D4647-1	1	4	0
	D4664-5	6	7	0
	D4712-1	1	13	0
	D4732-17	1	26	0
	D4732-23	1	12	0
	D4732-27	1	12	0
	D5021-5	1	3	0
	MPNY-750S-9-C	9	104	0
	MS20426AD4-6	2	873	0
	MS21059L08	2	139	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Skid-tube ☐ ☐ ☐
Machining ☐ ☐ ☐
Large Fab ☐ ☐ ☐

Cross tube ☐ ☐ ☐
Small Fab ☐ ☐ ☐
Finishing ☐ ☐ ☐

Eng. (Non-AW) ☐ ☐ ☐
Prod. Eng. Coord. ☐ ☐ ☐
Rec/Store/Packaging ☐ ☐ ☐
Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐
Handling/Presservation ☐ ☐ ☐
Material ☐ ☐ ☐
Product Improvement ☐ ☐ ☐
Process Improvement ☐ ☐ ☐
Human Factors ☐ ☐ ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
☐	☐	☐	☐
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
☐	☐	☐	☐
Crushing	BOM/Route	Grain Direction	Drawing
☐	☐	☐	☐
Cracks	Broken/Damage/Defect	Weld	Finish
☐	☐	☐	☐
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
☐	☐	☐	☐
Marks/Chatter	Drill Holes	Out of Sequence	Misread
☐	☐	☐	☐
Mislabeled	Fit/Function	Off-set/Set-up	
☐	☐	☐	

Other/Details: _____